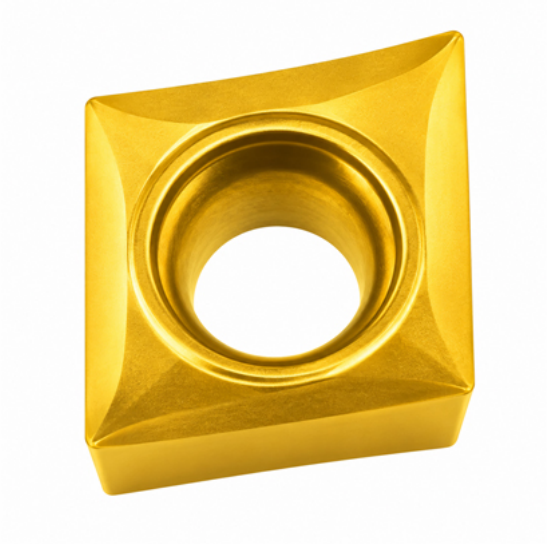
CCGT-ML

ZANHO Cutting Tools



Feature

ZANHO **CCGT-ML series**: Precision ground **80° rhombic inserts** with the ML chipbreaker for high-performance finishing. Optimized for **Stainless Steel** and **Hardened Steel (50HRC+)**, these

inserts provide stable chip control and exceptional surface smoothness. Ideal for high-speed precision CNC turning where tool life and dimensional accuracy are critical.

Descriptions

Technical Features

- **80° Rhombic Profile:** Versatile geometry providing optimal edge strength for finish turning.
- **ML Chipbreaker:** Mandatory chip curling design for adhesive stainless and hardened steel grades.
- **Dual-Material Performance:** Superior results on both Stainless Steel and Hardened Steel (50HRC+).
- **Optical Surface Finish:** Precision ground edges minimize friction and heat for a high-gloss finish.
- **High-Speed Stability:** Supports line speeds up to 200 m/min in stainless steel applications.

CCGT-ML Dimensions (mm)

Designation	L	øI.C	S	D1	RE
CCGT060201-ML	6.4	6.35	2.38	2.8	0.1
CCGT060202-ML					0.2
CCGT060204-ML					0.4
CCGT09T301-ML	9.7	9.525	3.97	4.4	0.1
CCGT09T302-ML					0.2
CCGT09T304-ML					0.4

Recommended Cutting Parameters

Tip Radius (RE)	ap (mm)	Vc Stainless (m/min)	Vc HRC50+ (m/min)	f (mm/rev)
R0.1	0.05-1.0	70-200	30-70	0.01-0.05
R0.2	0.08-1.5			0.02-0.08
R0.4	0.15-2.5			0.03-0.15